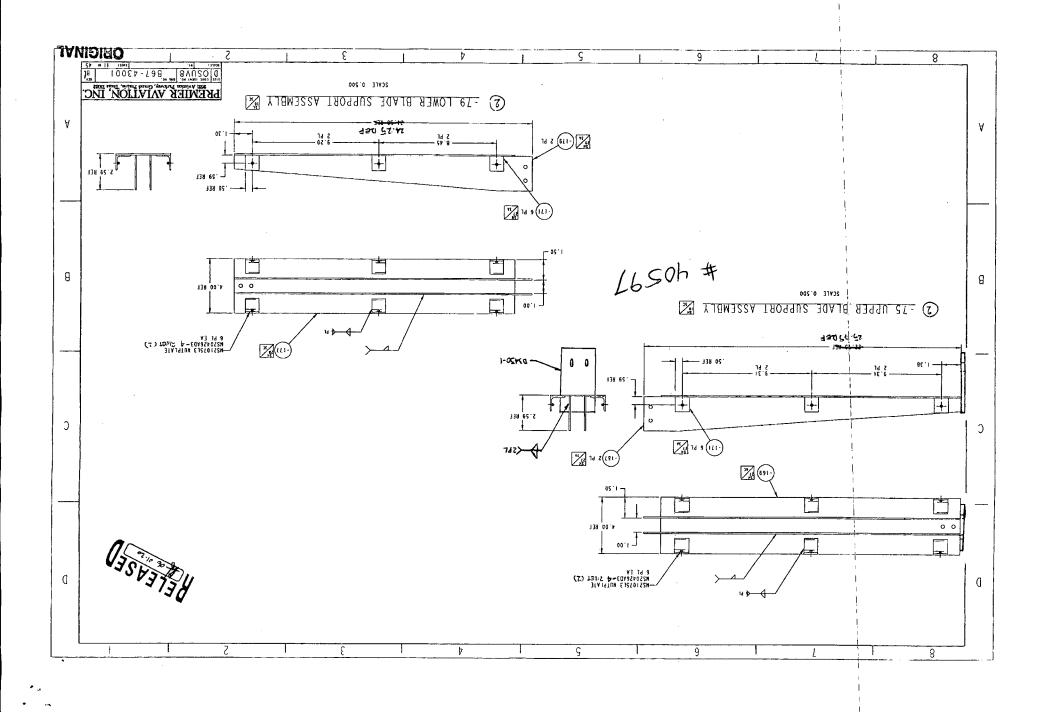
DART AEROSPACE LTD	Work Order:	39952
	Part Number	367-43001-75
Description: -75 Upper Blade Support Mas.	Part Number.	067 1.287
Dwg: 367 - 4/300 / SHEET 11	Qty:	10 102
		Page of

				D	Deta	Oty
	Step	Location	Procedure	Ву	Date	Qty
	1	DC	Issue Traveler			
	aut	GANY	Long Support plate - 169 we mat: 090 40,61 TG al. (m7) cut 21.50" x 4.00" mark part for Loles planse	950) *\VY	09.0b.26	1
a.		.7	Patron 110029 PHO743001-119	\mathcal{U}		
	cut	GANT	Long side plate - 167 use mal . 686 60 61 The al. (m/s. eut 25. 75" x 2.50" mark part cut off augle	36	+ A 36	2
		3	mark holes drill holes as per dwg. deburr By to be 4 5028 PM 74301-167 mounting plate - 171 use mat - AND 10133-1002 20617	4	/	12 /
*	Cut	GAW	QQ-A-200/2F Al Mat: 090 thk, 60 61 The QQ-A-200 Cut I"X I" mark holes for but plate will holes	1 / VIE) . 16	100
		7	1938 in certer of 098 each side of hole	h	8 No. 26	(20)
	if	<i>i</i>	circated sink Holes as per duy.	3	08/07/04	10
	ustal	VGH	ustall suft plate (m52107513N) (m16255) using their m520436AD3-4 (m9748) to mounting plate-P	13	08/07/10	120
	ustafi	110		1	1	
	Wester	W (4	weld parts -169 & -167 & -171 as per dwg. use 1" spaces (square tube) for gap between sid plate -167 and great flush.	ell	28.01.17	
	Hem	FR	clemical convertion coper fact as 5 005 4.1.		1	
	8	60				
	fact	tr -	powder coat green santey	1		
	9	003	annal Courter Cont.			
	10	ST	Qdenlife & Stock	ļ		
	11	OF DC	Level 21			
- 8		0	Charle Might weld to Current Stee	शंज	- ଜ-ମ - । ଏ	
V	GB.	QC5	Lapped word were se curum Step	 		
	L	L		L	<u> </u>	·

Rev	Date	Change		Revised By	Approved
			PRELIMINARY ISSU		
·			I LIFTIMIINAUT 1990		



Thursday, 17/07/2008 1:36:10 PM Date: User: Melanie Fauteux **Process Sheet** Drawing Name: UPPER BLADE SUPPORT ASSY Customer: CU-DAR001 Dart Helicopters Services Job Number: 40597 **Part Number: PB674300175** Job Number: Seq. #: **Description: Machine Or Operation:** 6.0 QC9 VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION 08-07-18 QC5 INSPECT WORK TO CURRENT STEP 7.0 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING M102316 Comment: POWDER COATING 1- put screws in nut plates before powder coating to keep thread clean 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 10.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 11.0 QC21 FINAL INSPECTION/W/O RELEASE 08/08/20/ Comment: FINAL INSPECTION/W/O RELEASE U St. 18.19 Job Completion -

Each

: UPPER BLADE SUPPORT ASSY

: PB674300175

: 24/07/2008

: N/A

: B1

: B6743001 P.11

Thursday, 17/07/2008 1:36:10 PM

Melanie Fauteux

Process Sheet

Drawing Name

Part Number

Material

Due Date

Description:

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Job Number

: 40597

Estimate Number

: 13471

P.O. Number

Prsht Rev.

Comment

This Issue

: 17/07/2008

: NC

First Issue : //

Previous Run

Written By

Checked & Approved By

: Est Rev:A

08-07-17 new issue DD verified by:ec

: LARGE FAB ASSY

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

PB6743001167 1.0

Comment: Qty.:

2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Long Side Plate

Long Side Plate

PB6743001169

Long Support Plate



2.0

3.0

4.0

Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Long Support Plate

PB6743001171

Mounting Plate



D34501

Comment: Qty.:

Mounting_Plate

6.0000 Each(s)/Unit Total: 60.0000 Each(s)

batch: 337670

Reinforcement Plate



Comment: Qty.:

1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Reinforcement_Plate

LARGE FAB 1 5.0

LARGE FABRICATION RESOURCE 1



Comment: Weld assembly as per dwg PB67-43001

Page 1